

Work Order ID 71731

Monday, July 11, 2011 11:09:03 AM

Page 1

Item ID: D4277-9

Accept

Revision ID:

Item Name: Rib

Start Date: 7/11/2011 Start Qty: 2.00

Required Date: 7/21/2011 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date: 7-07-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4277

D

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D4277
2- Remove marking, deburr

11.07.20 ②

110

0.00



QC

QC6- Inspect dimensions to drawing

Memo

0.00

Quality Control

8/11/20

②

120

0.00



Packaging

Identify as per dwg & Stock Location:

B/C

Memo

0.00

Packaging

STOCK IN BASKET CELL

11.07.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71731

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Page 2

Item ID: D4277-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 7/11/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/21

ME
11-07-20

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, July 11, 2011 11:09:10 AM

Page 1

Work Order ID: 71731

Parent Item: D4277-9

Parent Item Name: Rib



Start Date: 7/11/2011

Required Date: 7/21/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.11.12 new issue DD verf:EC
11.01.20 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TS0.500W.049

Purchased

No

100

f

736.7760

1.125

2.368421



11.07.20

Square Tubing

Location

Loc Qty

Loc Code

MAT034

736.776

116610

0.8383

11721

131.9377

117999

604

2.3684

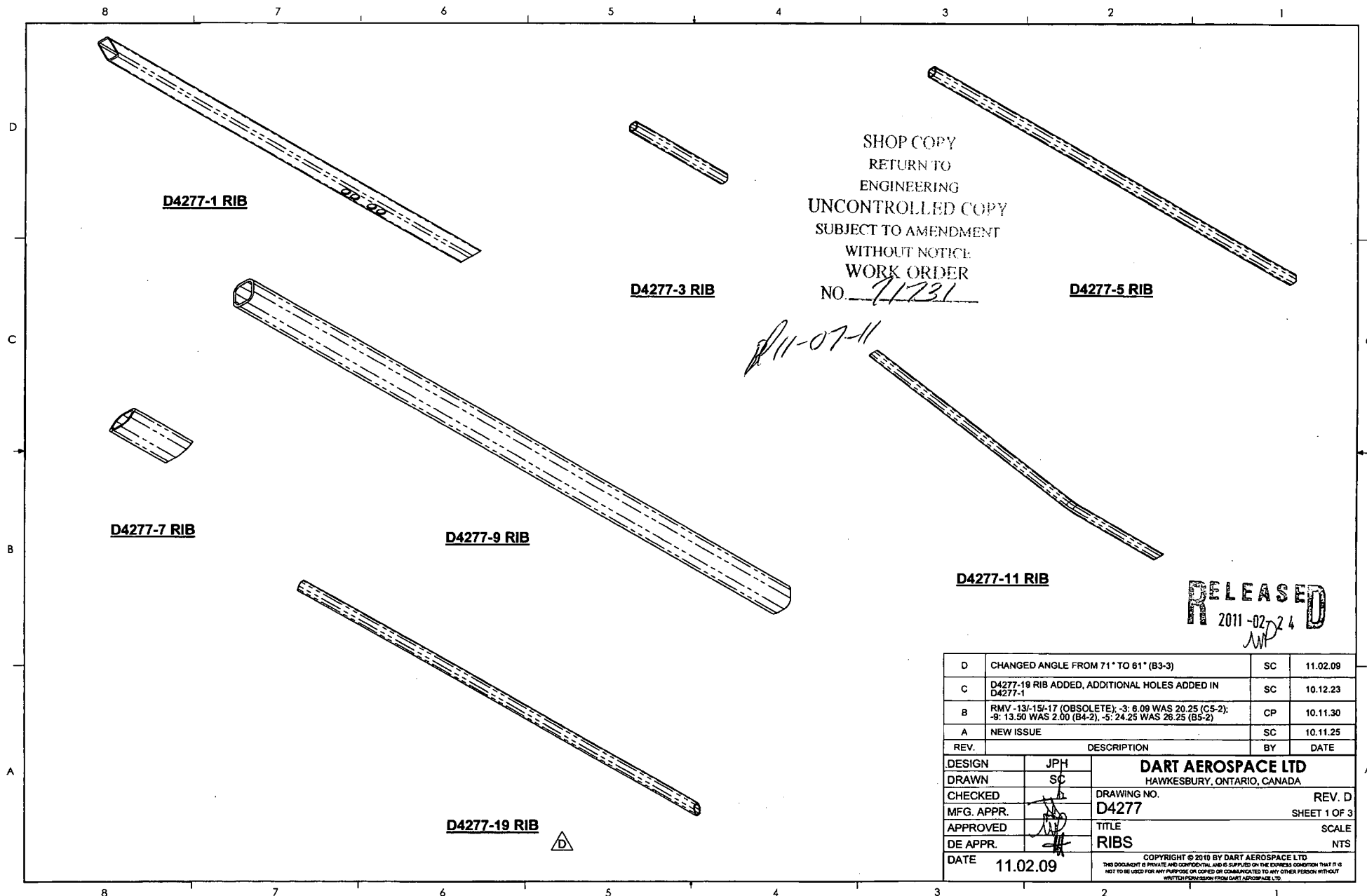
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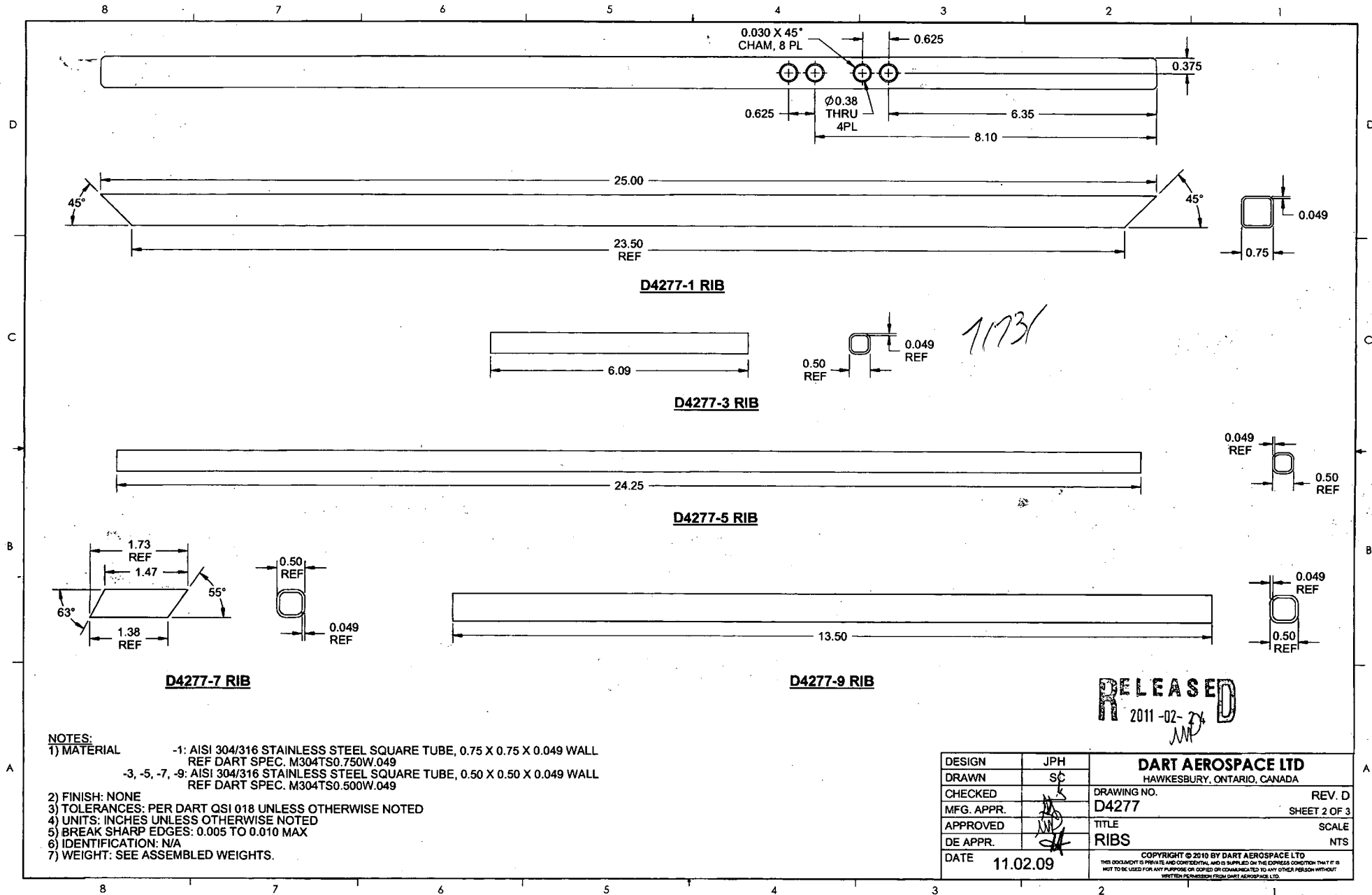
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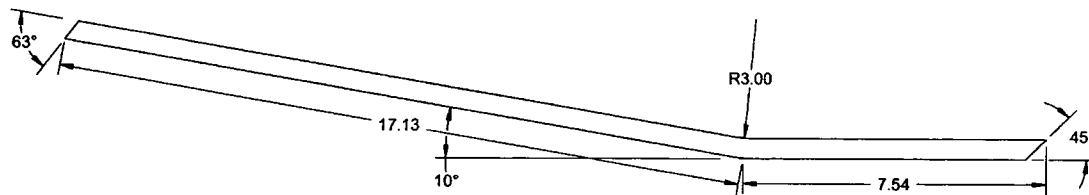
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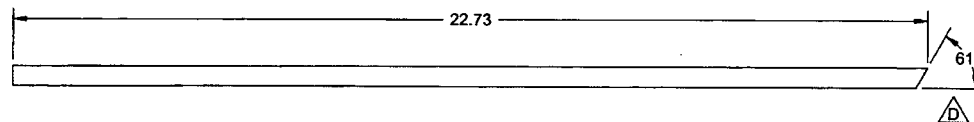
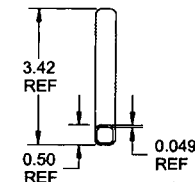
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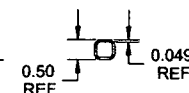
NOTE: Date & initial all entries



D4277-11 RIB



D4277-19 RIB



71731

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL -11, -19: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS.

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	K	DRAWING NO. D4277	REV. D SHEET 3 OF 3
MFG. APPR.		TITLE RIBS	SCALE NTS
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DE APPR.			
DATE	11.02.09		

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